

BLUE

Dart Aerospace Ltd.

23

Date: Wednesday, 5/16/2007 8:13:23 AM  
User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: LUG ASSEMBLY 206L/407 GHW LUG		
Job Number	: 32376					
Estimate Number	: 10318					
P.O. Number	: N/A			Part Number	: D2659	
This Issue	: 5/16/2007			Drawing Number	: D2659 REV A	
Prsht Rev.	: NC			Project Number	: N/A	
First Issue	: N/A			Drawing Revision	: A	
Previous Run	: 32018			Material	: N/A	
Written By				Due Date	: 6/6/2007	
Checked & Approved By				Qty:	32	
Comment	: Est: D 0209.20 Re-format; Incorporated D2657; D2658 KJ/RF			Um:	Each	

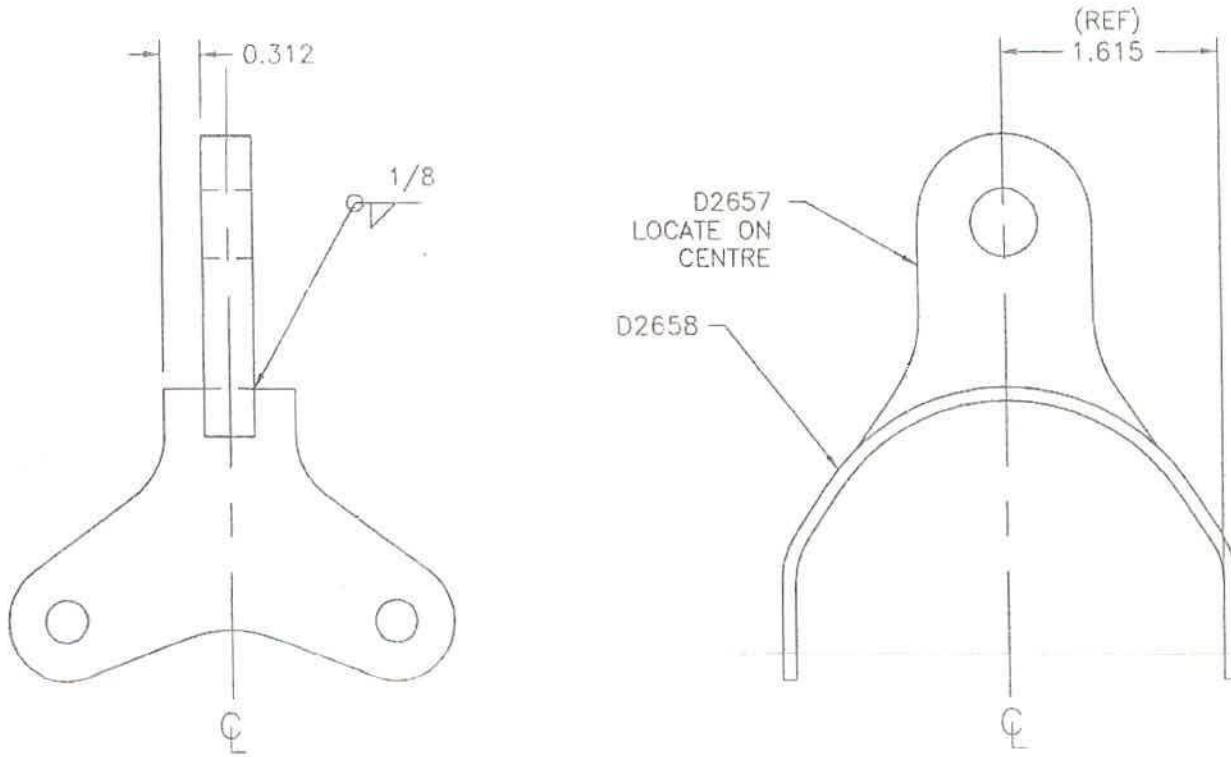
## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:	
1.0	32376A	LUG	26 2X B 32018
			FC 07/06/22
Comment: Sub-Component LUG D2657 B 2X B 29228 A			
2.0	32376B	LUG BRACKET	
			FC 07/06/22
Comment: Sub-Component LUG BRACKET D2658 B 32376B			
3.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1	
			FC 07/06/22
Comment: LARGE FABRICATION RESOURCE 1			
			1-Weld as per Dwg D2659 using location Jig DT8484
			AR/Steel Rod 4103794
4.0	QC9	VISUAL WELDING INSPECTION	
			10 07/06/22
Comment: VISUAL WELDING INSPECTION			
5.0	QC5	INSPECT WORK TO CURRENT STEP	
			10 07/06/22
Comment: INSPECT WORK TO CURRENT STEP			
6.0	SPRAY PAINTING	SPRAY PAINTING	
			10 07/06/22
Comment: SPRAY PAINTING			
			-PRIME
			-PAINT DELFLEET BLUE





D2659 LUG ASSEMBLY

WELD PER DART QSI 004  
 FINISH: POWDER COAT PER DART QSI 005 4.4  
 TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED  
 PART IS SYMMETRIC ABOUT CENTRE-LINES (Q)

SHOW LUMA  
 LETTERS TO  
 ENGINEER INC  
 INCONCRETE DESIGN  
 SUBJECT TO CONTRACT  
 WITHOUT NOTICE  
 32376

**DART**

DA COPY  
 1997

DESIGN	DRAWN BY	DART AEROSPACE LTD
MR	DR	VICTORIA INTERNATIONAL AIRPORT, CANADA
CHECKED	APPROVED	DRAWING NO.
<i>[Signature]</i>	<i>[Signature]</i>	D2659
DATE	97.11.03	REV. A
TIME		SHEET 1 OF 1
LUG ASSEMBLY		SCALE
A	97.11.03	NTS
	NEW ISSUE	

RELEASE  
 97.11.03 ps